

Date: Wednesday, 5/31/2006 7:32:01 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FOLDING STEP WELDMENT LH
Job Number : 27268	
Estimate Number : 10463	
P.O. Number : N/A	Part Number : D3388041
This Issue : 5/31/2006	Drawing Number : D3388 REV A
S.O. No. : N/A	Project Number : N/A
Prsht Rev. : NC	Drawing Revision : A
First Issue : N/A	Material : N/A
Type : LARGE FAB ASSY	Due Date : 6/18/2006
Previous Run : 27086	Qty: 5 Um: Each
Written By : <i>See Comment Below</i>	
Checked & Approved By : <i>06.05.31 W</i>	
Comment : Est. B 05.06.10 Added Step 11 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

D2622-120C extrusion 8

Batch: *B27077*

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622-120C extrusion 85.15" long as per Dwg D3388

2-Deburr and bevel ends for welding

PE 06.07.04 5*PE 06.07.04* 5

3.0	D2734	206 Step Endplate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>B24402</i>

PE 06.07.04 5

4.0	D33871	Arm
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
2	D3387-1	Arm	<i>B27288</i>

PE 06.07.04 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: FOLDING STEP WELDMENT LH

Job Number: 27268

Part Number: D3388041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024. Dwg Rev: H

Grind end cap welds flush

FF 06-07-06

(P70)

5

(P70)

5

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06-07-08

(5)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

am 06-07-19

(5)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

FC 06 07 20

(5)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect Powder Coat and Wing Walk

Jan 01
(5)

10.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Spacer

Pick:

Qty

Part Number

Description

Batch

1

D2808

Spacer

B27564

SAD 06-08-01

(5)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press spacer into D3387-1 arm as per Dwg D3387

SAD 06-08-01

(5)

5.1 QC5/QC9 Inspect weld

06-07-06 / 06/07/06

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
	6.1	QC 3 Inspect Abalone.	<i>[Signature]</i>	06.07.10	5	<i>[Signature]</i>	<i>[Signature]</i>
	6.2	weld last end CAPAS per Dwg D3388: Inspect ^{for} integrity	<i>[Signature]</i>	06.07.18	5		
	6.3	grind flush	FF	06.07.18	5		
	6.4	Abalone cap AS per QSI COS 4.1: Touch-up abalone as req'd.	2/M	06.07.19	5		
	6.4	QC 5/9 Inspect work: welds.	<i>[Signature]</i>	06.07.08	5		
permanent change <i>[Signature]</i>							

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 06/08/09

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-01 (5)

06-08-01 (5)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-4

06-08-08 (5)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/09 (5)

Job Completion



06-08-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

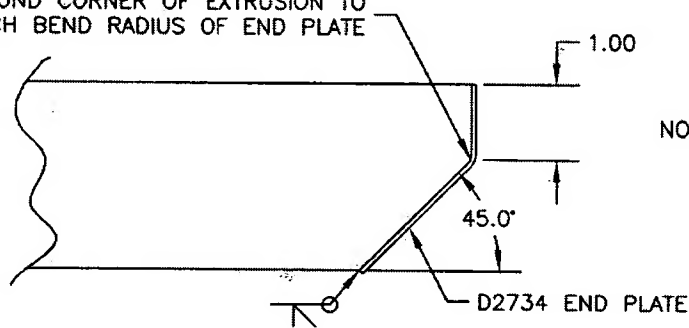


RELEASED

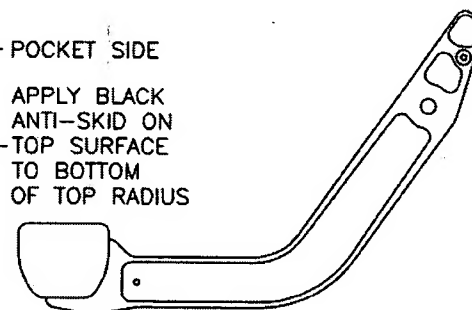
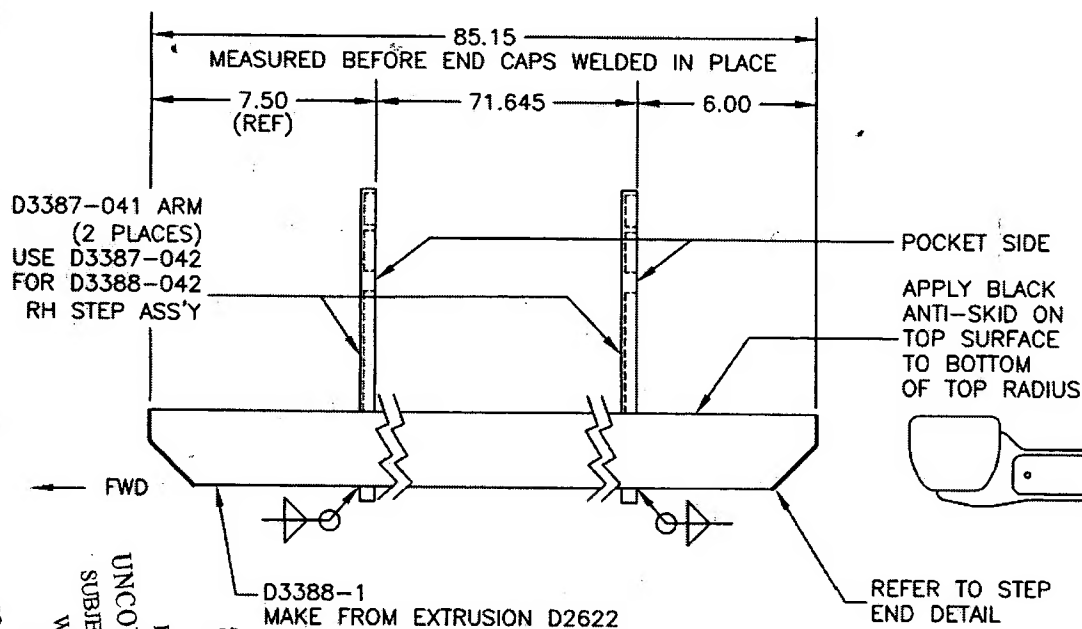
05-03-11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



D3387-041 ARM
(2 PLACES)
USE D3387-042
FOR D3388-042
RH STEP ASS'Y

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
27268

D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD
05-03-11	05-01-20	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05-01-20	05-01-20	D3388
DATE	TITLE	REV. A
05-01-20	STEP WELDMENT	SHEET 1 OF 1
A	NEW ISSUE	SCALE
		NTS